

Date: Friday, 18/07/2008 1:10:15 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001-Dart Helicopters Services Drawing Name : CABIN-FLOOR-PROTECTOR
Job Number : 40644
Estimate Number : 12660
P.O. Number : Part Number : D35741
This Issue : 18/07/2008 S.O. No. : Drawing Number : D3574 REV.A
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : SMALL /MED FAB Drawing Revision : A
Previous Run : 38609 Material :
Written By : Due Date : 31/07/2008 Qty: 4 Um: Each
Checked & Approved By : JLO 08.7.18
Comment : Est Rev :A New Issue 07-01-22 EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MLEXS125F6002904

GE PLASTICS LEXAN SHEET



Comment: Qty.: 33.6000 sf(s)/Unit Total : 134.4000 sf(s)
lexan sheet

Batch: 105330 IB 8-7-21

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3574
Dwg Rev: A
Prog Rev: A

IB 8-7-21(4)

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-7-22

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 08/07/23 (74)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 08/07/26 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:10:15 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 40644

Part Number: D35741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/2008 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: PPP 40629

AS 08/07/2008 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/31

Job Completion



MF 08-07-31

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40644
Description: Cabin Floor Protector		Part Number: D3574-1
Inspection Dwg: D3574	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	2.99	<input checked="" type="checkbox"/>		Tape measure	
7.37	+/-0.030	7.37	<input checked="" type="checkbox"/>			
11.00	+/-0.030	11.00	<input checked="" type="checkbox"/>			
15.25	+/-0.030	15.25	<input checked="" type="checkbox"/>			
25.87	+/-0.030	25.87	<input checked="" type="checkbox"/>			
39.75	+/-0.030	39.75	<input checked="" type="checkbox"/>			
44.75	+/-0.030	44.75	<input checked="" type="checkbox"/>			
53.51	+/-0.030	53.51	<input checked="" type="checkbox"/>			
63.50	+/-0.030	63.50	<input checked="" type="checkbox"/>			
65.25	+/-0.030	65.25	<input checked="" type="checkbox"/>			
10.75	+/-0.030	10.75	<input checked="" type="checkbox"/>			
14.75	+/-0.030	14.75	<input checked="" type="checkbox"/>			
25.50	+/-0.030	25.50	<input checked="" type="checkbox"/>			
25.75	+/-0.030	25.75	<input checked="" type="checkbox"/>			
26.00	+/-0.030	26.00	<input checked="" type="checkbox"/>			
32.87	+/-0.030	32.87	<input checked="" type="checkbox"/>			
38.81	+/-0.030	38.81	<input checked="" type="checkbox"/>			
45.00	+/-0.030	45.00	<input checked="" type="checkbox"/>			
47.75	+/-0.030	47.75	<input checked="" type="checkbox"/>		Remove	cannot measure
58.38	+/-0.030	58.38	<input checked="" type="checkbox"/>		Tape measure	
61.25	+/-0.030	61.25	<input checked="" type="checkbox"/>			
64.13	+/-0.030	64.13	<input checked="" type="checkbox"/>			
64.63	+/-0.030	64.63	<input checked="" type="checkbox"/>			
7.50	+/-0.030	7.50	<input checked="" type="checkbox"/>			
9.50	+/-0.030	9.50	<input checked="" type="checkbox"/>			
10.38	+/-0.030	10.38	<input checked="" type="checkbox"/>			
10.88	+/-0.030	10.88	<input checked="" type="checkbox"/>			
14.50	+/-0.030	14.50	<input checked="" type="checkbox"/>			

[Signature]

08/07/23

DART AEROSPACE LTD		Work Order: 40644
Description: Cabin Floor Protector		Part Number: D3574-1
Inspection Dwg: D3574	Rev: A	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

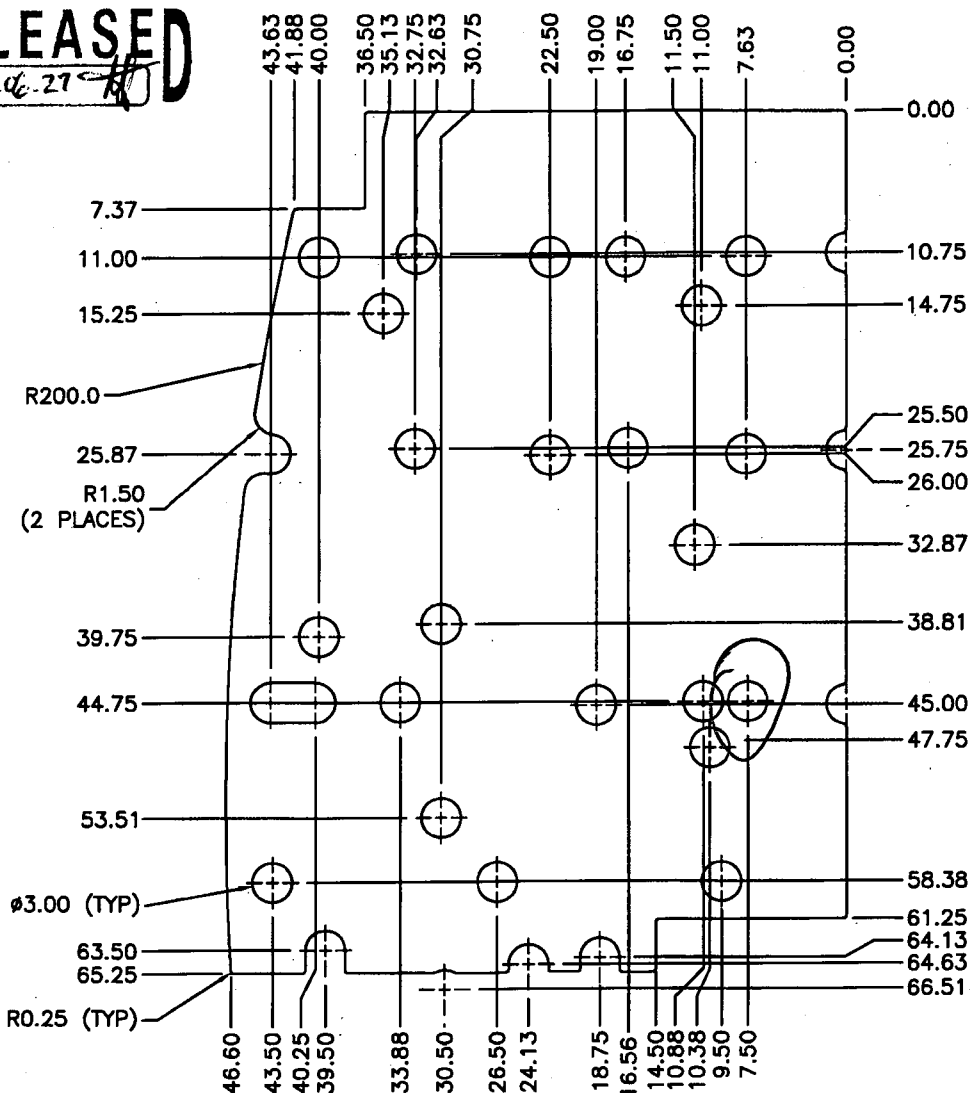
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	*		Tape measure	
18.75	+/-0.030	18.75	*			
24.13	+/-0.030	24.13	*			
26.50	+/-0.030	26.50	*			
30.50	+/-0.030	30.50	*			
33.88	+/-0.030	33.88	*			
39.50	+/-0.030	39.50	*			
40.25	+/-0.030	40.25	*			
43.50	+/-0.030	43.50	*			
46.60	+/-0.030	46.60	*			
7.63	+/-0.030	7.63	*			
11.00	+/-0.030	11.00	*			
11.50	+/-0.030	11.50	*			
16.75	+/-0.030	16.75	*			
19.00	+/-0.030	19.00	*			
22.50	+/-0.030	22.50	*			
30.75	+/-0.030	30.75	*			
32.63	+/-0.030	32.63	*			
32.75	+/-0.030	32.75	*			
35.13	+/-0.030	35.13	*			
36.50	+/-0.030	36.50	*			
40.00	+/-0.030	40.00	*			
41.88	+/-0.030	41.88	*			
43.63	+/-0.030	43.63	*			

Measured by: RB	Audited by: S	Prototype Approval: N/A
Date: 8-7-22	Date: 08/07/23	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	DA

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07.06.27

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NO. 40644

D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)**NOTES:**

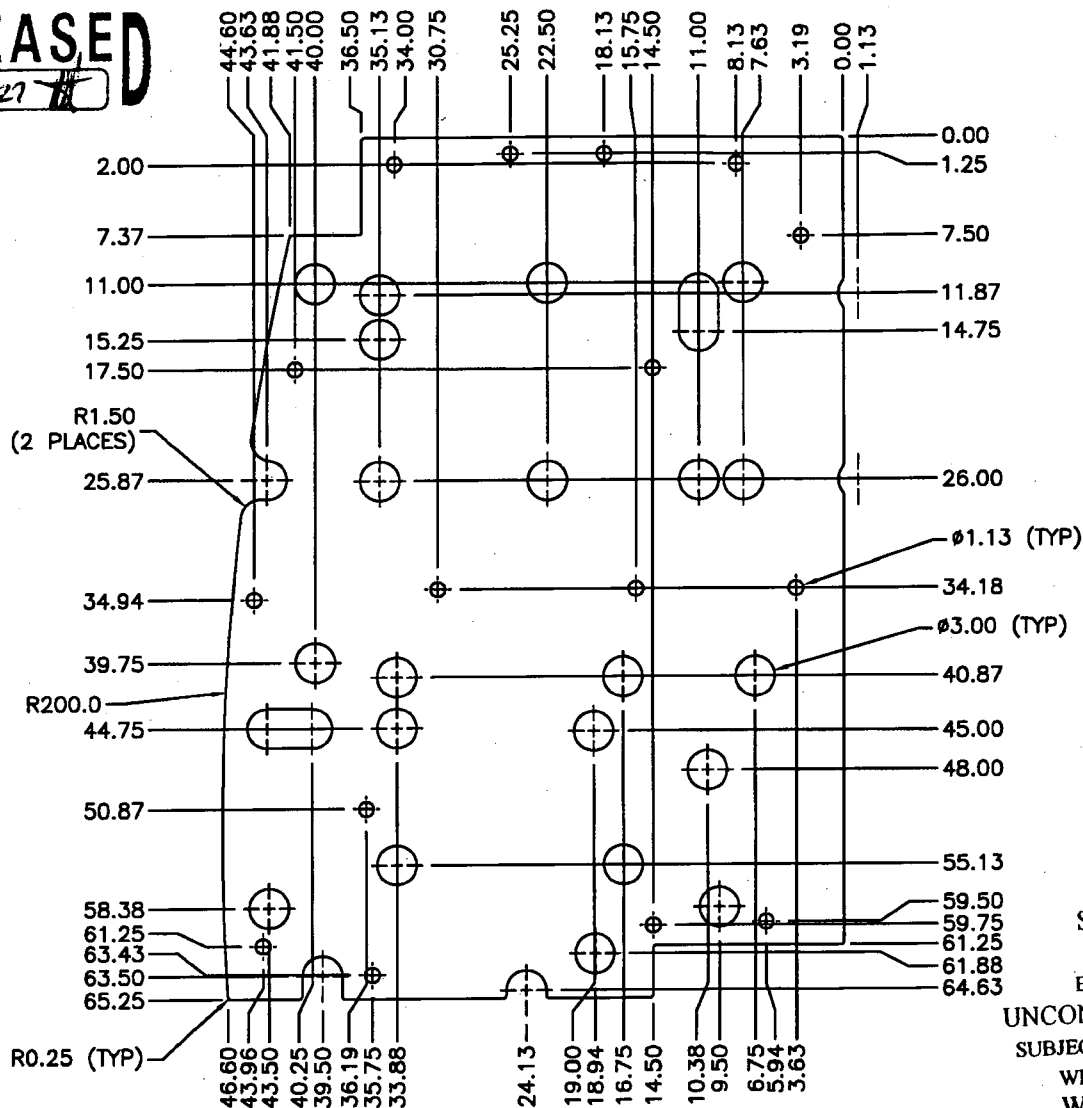
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

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07.06.27

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D3574-3 CABIN FLOOR PROTECTOR**NOTES:**

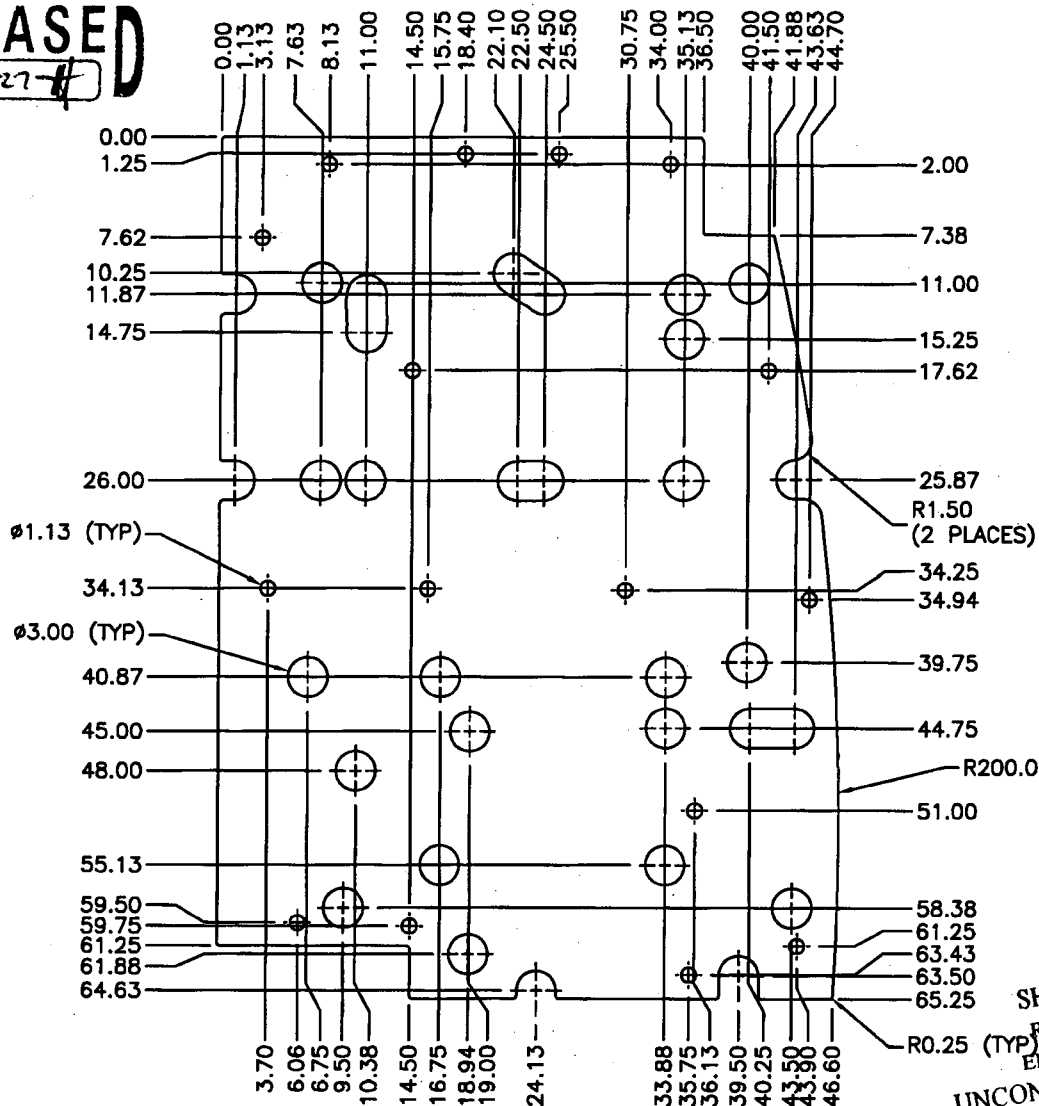
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

RELEASED
07.06.27**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

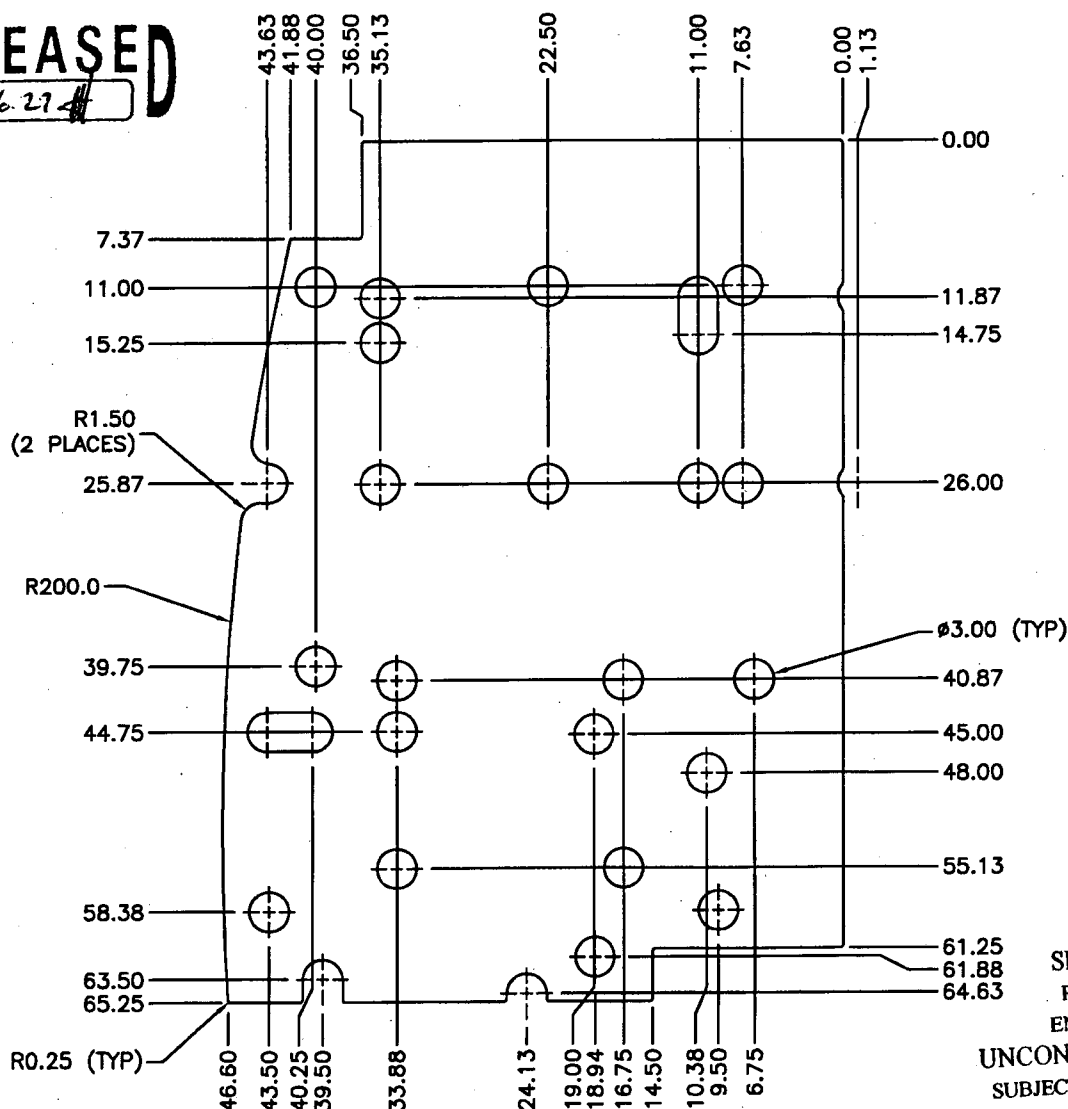
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27.4**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

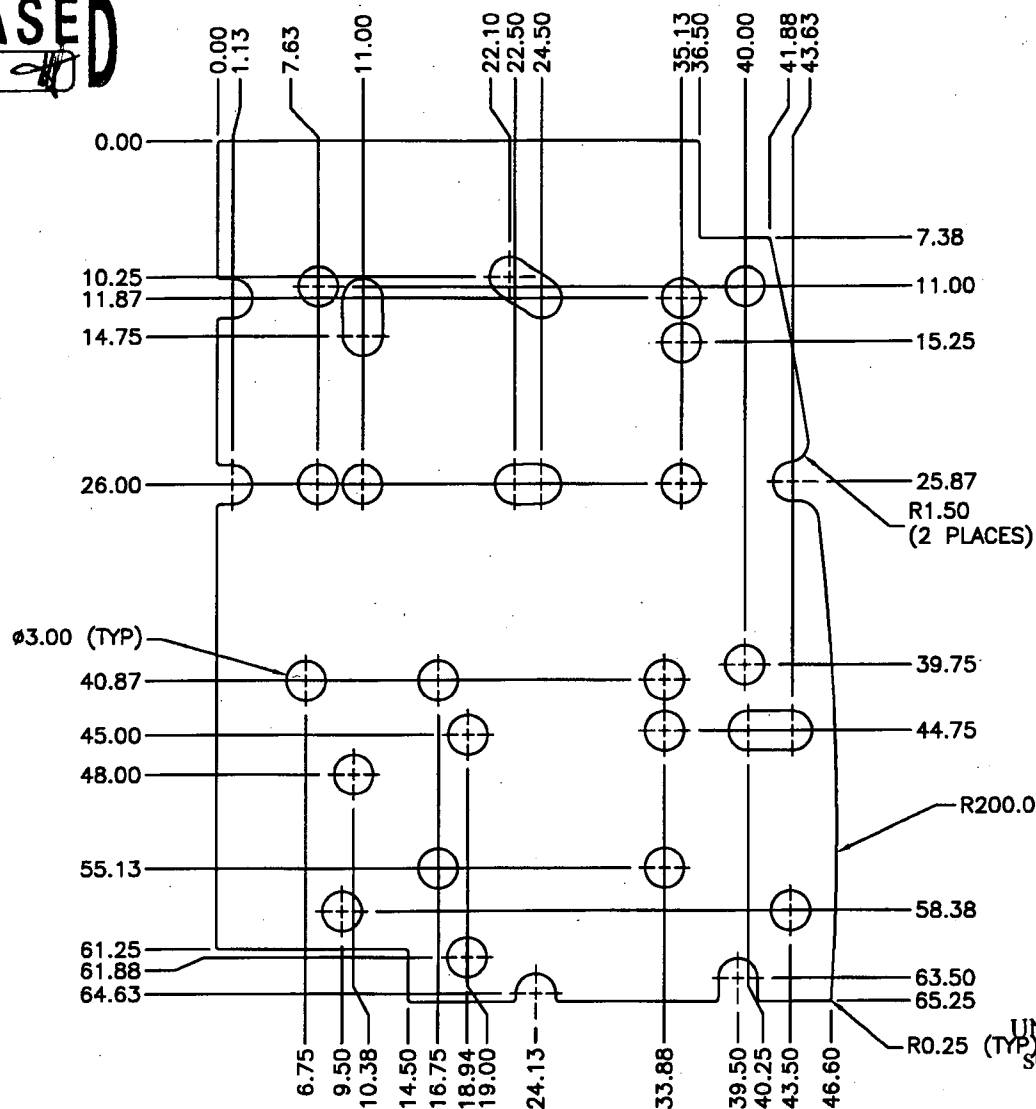
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
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